

Date: Wednesday, 22/10/2008 11:47:18 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number : 42804	
Estimate Number : 10533	
P.O. Number :	Part Number : D2573
This Issue : 22/10/2008 S.O. No. :	Drawing Number : D2573 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision :
Previous Run : 35917	Material :
Written By :	Due Date : 06/01/2009 Qty: 12 Um: Each
Checked & Approved By : <u>JLD 08.10.22</u>	
Comment : Est: I As Per RevE 06-01-27 JLM	

Additional Product

Job Number:



Séq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D6101007	Saddle Billet
-----	----------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
 7075-T7351 8.25X7.75X2.5
 Make from D6101-007 billet for D2573
 Ensure that grain is along 7.75" length
 Batch No: B 41960

JLD 08/10/31

(12)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No. 42804 Double check by: JLD

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
 4-Deburr and remove all machining marks
 5-Tumble to remove sharp edges.

J.F. 08/11/03

(12)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D2573 & D2574

J.F. 08/11/03

(12)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/11/03

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 22/10/2008 11:47:18 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 42804

Part Number: D2573

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

RP 08/11/03 (12)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 08/11/04 (12)

7.0

POWDER COATING

POWDER COATING



M102316



(12x)

Comment: POWDER COATING

Powder Coat **SANDTEX GREEN**
(Ref: 4.3.5.1) as per QSI 005 4.3

M-A 08/11/04

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



MS



Comment: INSPECT POWDER COAT

08-11-04

(X12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 431

AS 08/11/05 (X2)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/06

Job Completion



MF 08-11-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 42804
Description: Saddle, Aft Outboard		Part Number: D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	Ø .440"	Ø .440"	Ø .440"		
B	1.745	1.755		1.750	1.750"	1.750"	1.750"		
C	3.495	3.505		3.500	3.500"	3.500"	3.500"		
D	1.745	1.755		1.750	1.750"	1.750"	1.750"		
E	7.990	8.010		8.000	8.000"	8.000"	8.000"		
F	0.490	0.510		.499	.506"	.503"	.510"		
G	0.257	0.262		.259	.260	Ø .258"	Ø .258"		
H	0.375	0.380		.377	.377	Ø .376"	Ø .376"		
I	0.490	0.510		.501	.503	.506"	.503"		
J	1.174	1.184		1.178	1.179	1.179"	1.179"		
K	0.558	0.578		.569	.570	.571"	.569"		
L	1.174	1.184		1.178	1.179	1.179"	1.179"		
M	1.365	1.375		1.369	1.369	1.372"	1.372"		
N	2.495	2.505		2.499	2.500	2.499"	2.499"		
O	4.119	4.129		4.123	4.122	4.123"	4.123"		
P	0.115	0.135		.126	.127	.127"	.127"		
Q	0.115	0.135		.135	.135	.135"	.135"		
R	0.240	0.260		.246	.250	.252"	.253"		
S	0.115	0.135		.127	.126	.125"	.125"		
T	0.178	0.198		.188	.188	R .188"	R .188"		
U	3.210	3.250		3.225	3.226	3.228"	3.228"		
V	0.230	0.250		.233	.235	.240"	.240"		
W	0.115	0.135		.127	.128	.125"	.126"		
X	0.308	0.313		.311	.311"	.311"	.310"		
Y	0.760	0.765		.760	.763"	.763"	.763"		
Z	0.352	0.372		.368	.368"	.368"	.368"		
AA	0.470	0.530		.500	.500	R .500"	R .500"		
AB	0.615	0.635		.631	.635"	.635"	.634"		
AC	0.053	0.073		.063	.063	R .063"	R .063"		
AD	0.240	0.260		.244	.247	.250"	.250"		
AE	1.500	1.520		1.515	1.515	1.512"	1.513"		
AF	0.115	0.135		.122	.122	.125"	.125"		
AG	0.240	0.280		.265	.265	.256"	.256"		
AH	0.240	0.260		.242	.246	.250"	.250"		
AI	2.000	2.020		2.002	2.003	2.002"	2.003"		
AJ	0.023	0.043		.033	R .033"	R .033"	R .033"		
Accept/Reject									

Measured by: <i>mk</i> / J.F.
Date: 05/10/31 / 08/11/01

Audited by: <i>24</i>
Date: 08/11/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>JA</i>

DART AEROSPACE LTD		Work Order: 42804
Description: Saddle, Aft Outboard		Part Number: D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	#5	#6	#7	#8	By	Date
A	0.438	0.443		0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.751	1.751		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.751		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		0.510	0.502	0.504	0.501		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.376	0.377	0.377	0.377		
I	0.490	0.510		0.504	0.505	0.504	0.505		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.569	0.571	0.572	0.572		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.372	1.372	1.372	1.372		
N	2.495	2.505		2.499	2.499	2.499	2.499		
O	4.119	4.129		4.123	4.123	4.123	4.123		
P	0.115	0.135		0.126	0.126	0.126	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.252	0.252	0.252	0.252		
S	0.115	0.135		0.125	0.125	0.125	0.125		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.228	3.228	3.228	3.228		
V	0.230	0.250		0.240	0.240	0.240	0.240		
W	0.115	0.135		0.127	0.127	0.126	0.130		
X	0.308	0.313		0.313	0.310	0.311	0.311		
Y	0.760	0.765		0.763	0.760	0.760	0.760		
Z	0.352	0.372		0.368	0.371	0.371	0.371		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.631	0.634	0.635	0.632		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.249	0.250	0.250		
AE	1.500	1.520		1.512	1.513	1.513	1.512		
AF	0.115	0.135		0.125	0.125	0.125	0.125		
AG	0.240	0.280		0.256	0.260	0.260	0.260		
AH	0.240	0.260		0.250	0.249	0.249	0.249		
AI	2.000	2.020		2.002	2.003	2.002	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: J.F.
Date: 08/11/01

Audited by: 20
Date: 08/11/01

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order: 42804
Description: Saddle, Aft Outboard		Part Number: D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				# 9	# 10	# 11	# 12		
A	0.438	0.443		0.440"	0.440"	0.440"	0.440"		
B	1.745	1.755		1.751"	1.751"	1.751"	1.751"		
C	3.495	3.505		3.500"	3.500"	3.500"	3.500"		
D	1.745	1.755		1.750"	1.750"	1.750"	1.750"		
E	7.990	8.010		8.000"	8.000"	8.000"	8.000"		
F	0.490	0.510		0.503"	0.504"	0.504"	0.505"		
G	0.257	0.262		0.258"	0.258"	0.258"	0.258"		
H	0.375	0.380		0.377"	0.377"	0.377"	0.377"		
I	0.490	0.510		0.504"	0.504"	0.505"	0.508"		
J	1.174	1.184		1.178"	1.178"	1.178"	1.178"		
K	0.558	0.578		0.570"	0.571"	0.571"	0.573"		
L	1.174	1.184		1.179"	1.179"	1.179"	1.179"		
M	1.365	1.375		1.371"	1.371"	1.371"	1.371"		
N	2.495	2.505		2.500"	2.500"	2.500"	2.500"		
O	4.119	4.129		4.123"	4.123"	4.123"	4.123"		
P	0.115	0.135		0.126"	0.126"	0.126"	0.126"		
Q	0.115	0.135		0.135"	0.135"	0.135"	0.135"		
R	0.240	0.260		0.252"	0.252"	0.252"	0.252"		
S	0.115	0.135		0.123"	0.125"	0.123"	0.124"		
T	0.178	0.198		R.188"	R.188"	R.188"	R.188"		
U	3.210	3.250		3.229"	3.229"	3.229"	3.229"		
V	0.230	0.250		0.240"	0.242"	0.240"	0.241"		
W	0.115	0.135		0.126"	0.128"	0.127"	0.125"		
X	0.308	0.313		0.311"	0.311"	0.311"	0.311"		
Y	0.760	0.765		0.760"	0.760"	0.760"	0.760"		
Z	0.352	0.372		0.371"	0.371"	0.371"	0.371"		
AA	0.470	0.530		R.500"	R.500"	R.500"	R.500"		
AB	0.615	0.635		0.634"	0.635"	0.635"	0.638"		
AC	0.053	0.073		R.063"	R.063"	R.063"	R.063"		
AD	0.240	0.260		0.250"	0.250"	0.250"	0.250"		
AE	1.500	1.520		1.513"	1.514"	1.513"	1.513"		
AF	0.115	0.135		0.125"	0.125"	0.125"	0.125"		
AG	0.240	0.280		0.270"	0.270"	0.270"	0.270"		
AH	0.240	0.260		0.249"	0.249"	0.250"	0.250"		
AI	2.000	2.020		2.003"	2.003"	2.003"	2.002"		
AJ	0.023	0.043		R.033"	R.033"	R.033"	R.033"		
Accept/Reject									

Measured by: J.F.
Date: 08/11/02

Audited by: [Signature]
Date: 08/11/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJJ/LM	[Signature]

05.12.0

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCRP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA
DS	PH		

CHECKED 	APPROVED 	DRAWING NO D2573
---	--	---------------------

DATE	TITLE
05.07.13	OUTER AFT SADDLE

REV. E
SHOP COPY
SHEET 1 OF 1
RETURN TO
SCALE
ENGINEERING
UNCONTROLLED COPY

SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42804

